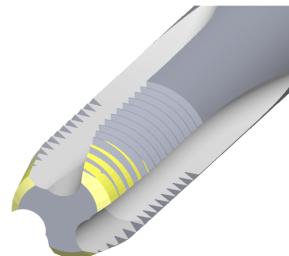
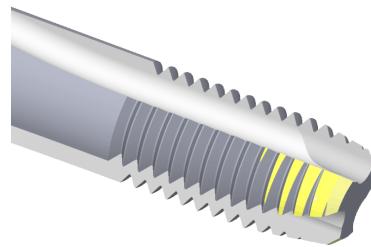


Spiral Pointed Tap M6 Z3

A10-020

The manufacturing cycle includes the loading and dressing cycle for conventional wheels for flute and thread grinding. After further research in wheel technology the cycle time could be reduced.



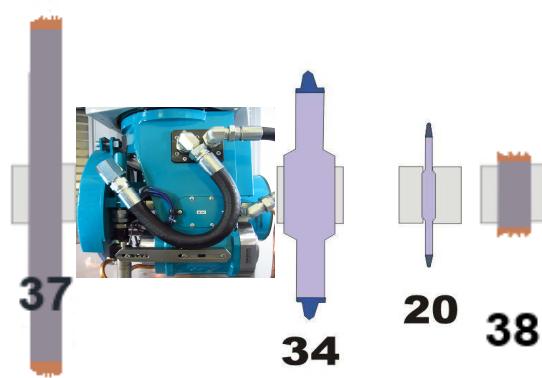
1. Cycletime for Production

Tool specifications M6, flutelength 20.3, Helix 0° Material HSSE							
Operations	Loading	Flute	Gash	Thread rough	Thread fine	Chamfer	dress flute
Feed [mm/Min]		1400	60	12000	12000	12000	100
Power [kW]		6	6	4	4	4	1
Cutting feed [m/s]		60	60	65	65	65	24
Used wheels		34	34	37	37	37	20
Grinding time [s]	20	21	20	25	18	21	16
Total cycle time	2 Min 53						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 Ø180 DXF A100
37 Ø400 1A1 A250
20 Ø125 14EE1 D301
38 Ø90 DXF D301



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : TAP NGM, dressing unit
Control: Fanuc 31i B5
Coolant: Synthetic Oil, pressure 9 bar
Software: Quinto 5.4.6

responsible engineer:

FFR,22.01.15

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